

Side View



- At this time "Y-1" (press feed valve) will open along with Y-2 and Y-3. Y-4 & Y-5 remain closed for a time of 2

- 3) With press in "Time" mode, press will continue until preset (stage 1) time elapses (15min)
- 4) At this point the PLC signals ACSV-1 to increase air pressure to 50psi for a preset time as indicated by stage 2

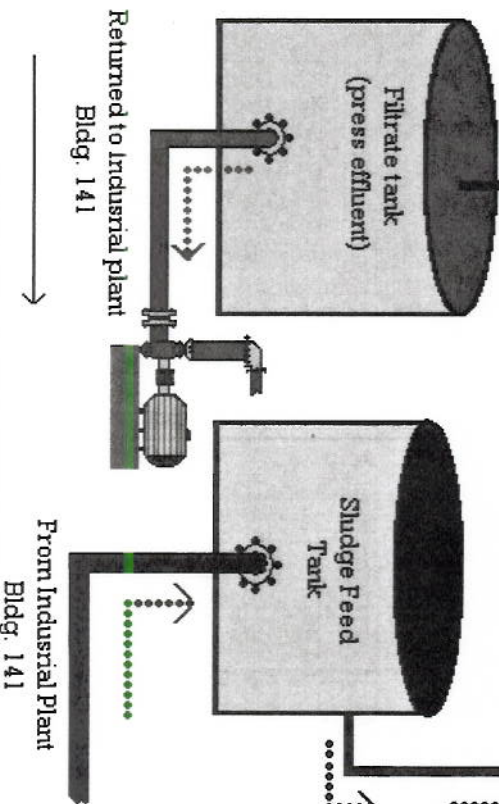
- 5) With time elapsed for stage 2, the PLC will again increase air pressure to pump "A" to 100 psi and operate at this rate for the programmed amount of time in stage 3

6) When stage 4 is reached, "V"-11 closes and "V"-10 opens sending the same 100psi to feed pump "B" which is a high pressure diaphragm pump & exerts double the pressure into the press. Converting a 100psi into 200psi which constitutes stage 4. Again with the press in "TIMED" mode will continue until prelap time is obtained.

7) When stage 4 is complete, the program calls for press to enter a "Core blow" mode. This final part of the operation signals for STV-14 (Solenoid Valve) to open position enabling a max. of 100psi into upper left filtrate line, forcing remaining sludge back thru "V-1". This process usually takes 2-5 minutes and avoids excess sludge drainage when opening press.

When press enters the Core Blow stage V-2, 3, 4 & 5 are signaled to close-allowing "blow back" only through V-1. At the conclusion of this stage all valves will close & "PRESS COMPLETE" annary in PLC screen

S. Fairweather
Sept. 2006



The 2 JWI presses have capability to operate in "FLOW" mode. (as opposed to "TIME mode") The difference being in flow mode a AUTOMATIC AIR FLOW SWITCH (AFS-1) is installed on the main air supply line and is monitored by the PLC. This device is programmable and signals the PLC when a preset time (3 to 5 seconds) elapses between air movement through air supply line. This lack of air movement translates the amount of time or space between the stroke of the feed pumps which indicates by the "stall" time that press is at maximum load.

